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RBEM622V4008101
Job Sheet 180846



005935

Part No: RBEM622V4008101

Job Qty: 1 ea

Part Name: Main Rotor Head Damper Setting Tool



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/17/18

Job Tracking No:

Due Date: 9/4/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBEM622V4008101 Rev. 3 IPP Rev. A 18.05.17 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	9/4/18	9/4/18	0.00	0.00	Start Up Small Fab-4		MLL
100	Small Fab	1 pcs	9/4/18	9/4/18	0.00	0.50	Small Fab-9		MLL DAS 38
110	QC	1 pcs	9/4/18	9/4/18	0.00	0.00	QC5		38
130	Packaging	1 pcs	9/4/18	9/4/18	0.00	0.00	Packaging3-2		MLL 3-89
140	QC21-FG	1 Ea	9/4/18	9/4/18	0.00	0.00	QC21		DAS 21 9-89

Part Op 100 - Assemble as per DWG.
Descriptions: 130 - Identify and Stock

OCT 17 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBEM622V4008101-1	Base	1 Ea (1 ea)	90-Start up Operation	5093512
92290A330	Socket Cap Screw	9 Ea (9 ea)	100-Small Fab	5077700
98381A510	Pin	2 Ea (2 ea)	100-Small Fab	5075952
RBEM622V4008101-11	Fastener	1 Ea (1 ea)	100-Small Fab	5108068
RBEM622V4008101-13	Fastener 2	1 Ea (1 ea)	100-Small Fab	5108611
RBEM622V4008101-15	Cap	4 Ea (4 ea)	100-Small Fab	5109109
RBEM622V4008101-17	Foam Block	2 Ea (2 ea)	100-Small Fab	5092100
RBEM622V4008101-3	Measurement Block	1 Ea (1 ea)	100-Small Fab	5092415
RBEM622V4008101-5	Support 1	1 Ea (1 ea)	100-Small Fab	5109410 5109664
RBEM622V4008101-7	Support 2	1 Ea (1 ea)	100-Small Fab	5109410
RBEM622V4008101-9	Support 3	1 Ea (1 ea)	100-Small Fab	5109722

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RBEM622V4008101-1	1	6	0
100-Small Fab	92290A330	9	25	0
	98381A510	2	50	0
	RBEM622V4008101-11	1	0	0
	RBEM622V4008101-13	1	0	0
	RBEM622V4008101-15	4	0	0
	RBEM622V4008101-17	2	24	0
	RBEM622V4008101-3	1	6	0
	RBEM622V4008101-5	1	0	0
	RBEM622V4008101-7	1	0	0
	RBEM622V4008101-9	1	0	0



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Container No: S118705

Part: FBEM622V4008101

Job No: 180846

Serial No/Batch: S118705

Revision: 3

Inspector:

Exp Date:

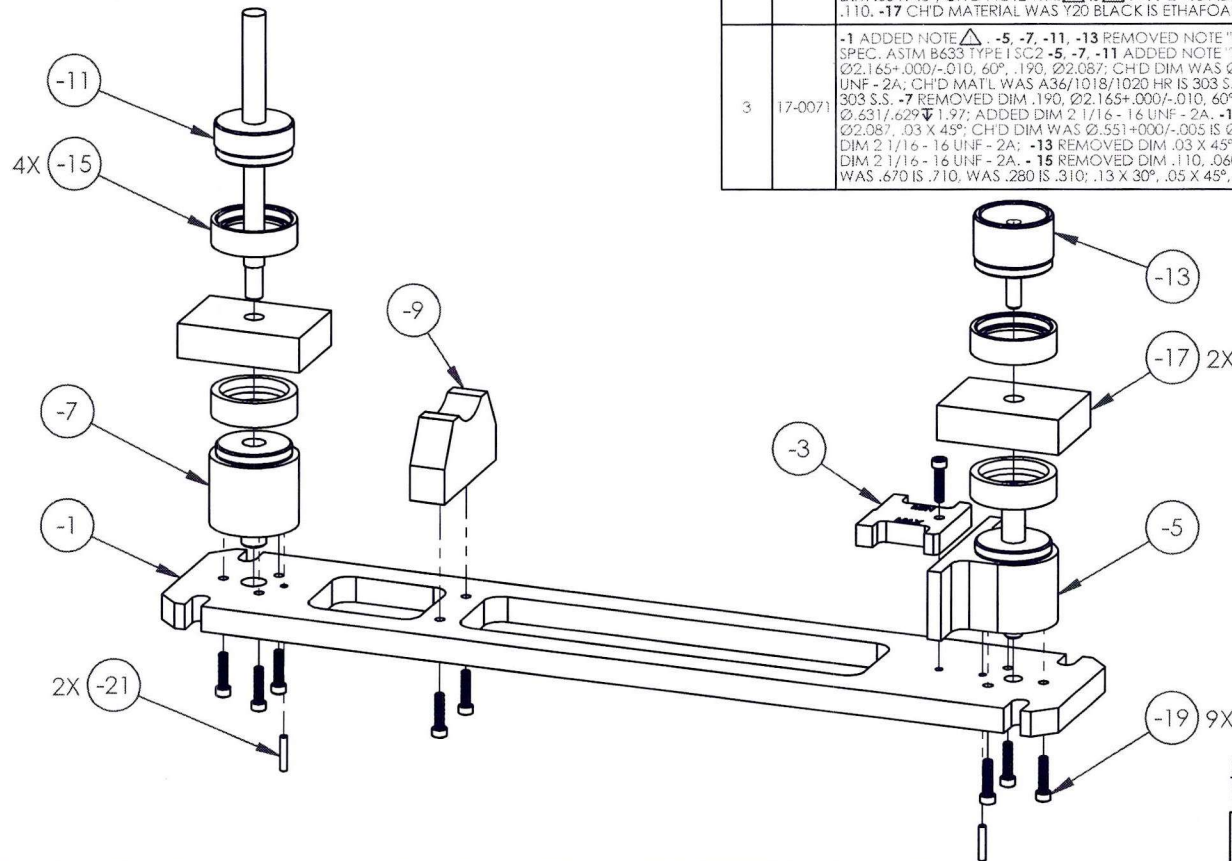
Instructions:

Date: 10/16/19

Part Specifications	
Specifications could not be found.	

Plex 8/8/18 9:26 AM dart.logan.david

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NOTE:
REF. AIRBUS T/N: M622V4008101.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	BASE	A36/1018/1020 HR		2
			-3	1	MEASUREMENT BLOCK	303 S.S.		3
			-5	1	SUPPORT 1	303 S.S.		4
			-7	1	SUPPORT 2	303 S.S.		5
			-9	1	SUPPORT 3	6061		6
			-11	1	FASTENER 1	303 S.S.		7
			-13	1	FASTENER 2	303 S.S.		8
			-15	4	CAP	BLACK DELRIN/ACETAL		9
		B/O	-17	2	FOAM BLOCK	ETHAFOAM 220, BLACK	3.50 X 2.45 X 1.00 (CASE SOLUTIONS)	10
		B/O	-19	9	SOCKET CAP SCREW	S.S.	M6 X 1 X 25MM (MCMASER-CARR # 92290A330)	1
		B/O	-21	2	PIN	STEEL	3/16 X 1 (MCMASER-CARR # 98381A510)	1

REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION			6/14/2016	SM	JAG
2	16-0173	-1 CHD DIM WAS 8X Ø.260 ∇ 2.63 IS 8X Ø.260 THRU ALL, CHD DIM WAS 3X 2.368 IS 7X 2.368, ADDED INK STAMP T/N, S/N, "MADE IN USA"; -3 CHD MATERIAL WAS A36/1018/1020 HR IS 303 S.S., MOVED ENGRAVE P/N NOTE LOCATION, DELETED NOTES 1, 2 AND 3; -5 CHD DIM WAS Ø2.165 IS Ø2.165+0.00/-0.10, ADDED BREAK EDGE NOTE; -7, -11, & -13 CHD MATL WAS A36/1018/1020 HR IS STRESSPROOF, CHD DIM WAS Ø2.165 IS Ø2.165+0.00/-0.10, ADDED BREAK EDGE NOTE; -7 ADDED DIM .05 X 45°, CHD NOTE WAS Δ IS Δ; -11 & -13 ADDED ENGRAVE P/N; -15 CHD DIM WAS .090 IS .110, -17 CHD MATERIAL WAS T20 BLACK IS ETHAFOAM 220, BLACK, (CASE SOLUTIONS);			10/17/2016	RJC	SM
3	17-0071	-1 ADDED NOTE Δ; -5, -7, -11, -13 REMOVED NOTE "BREAK EDGE", REMOVED FINISH ZINC PLATE SPEC, ASTM B633 TYPE I SC2; -5, -7, -11 ADDED NOTE "THREAD RELIEF"; -5 CHD REMOVED DIM Ø2.165+0.00/-0.10, 60°, .190, Ø2.087; CHD DIM WAS Ø.630 IS Ø.627/.625; ADDED DIM 2 1/16 - 16 UNF - 2A; CHD MATL WAS A36/1018/1020 HR IS 303 S.S.; -7, -11, -13 CHD MATL WAS STRESSPROOF IS 303 S.S.; -7 REMOVED DIM .190, Ø2.165+0.00/-0.10, 60°, Ø2.087; CHD DIM WAS Ø.625 ∇ 1.97 IS Ø.631/.629 ∇ 1.97; ADDED DIM 2 1/16 - 16 UNF - 2A; -11 REMOVED DIM Ø2.165+0.00/-0.10, 60°, .190, Ø2.087, .03 X 45°; CHD DIM WAS Ø.551+0.00/-0.005 IS Ø.551 $\pm$.003, WAS Ø.638 IS Ø.627/.625; ADDED DIM 2 1/16 - 16 UNF - 2A; -13 REMOVED DIM .03 X 45°, .190, 60°, Ø2.087, Ø2.165+0.00/-0.10; ADDED DIM 2 1/16 - 16 UNF - 2A; -15 REMOVED DIM .110, .060, .070, .140, .080, 12X .063, 11X 30°; CHD DIM WAS .670 IS .710, WAS .280 IS .310, .13 X 30°, .05 X 45°, Ø1.74, 2 1/16 - 16 UNF - 2B.			3/23/2017	SM	JAG

DART AEROSPACE	
TITLE MRH DAMPER SETTING TOOL	
DWG NO. RBEM622V4008101	REV 3
MAT'L HEAT TREAT FINISH	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS $\pm$ 1/8 XX $\pm$.01 ANGLES $\pm$ 5° X $\pm$.1 SURFACES = 125/✓
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: CLOUGH	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL H175
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:5	DATE 3/3/2016
SHEET 1 OF 11	